

# Work Order ID 86342

June-27-12 3:19:41 PM

**\*86342\***

Page 1

Item ID: D2435

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bearpaw, 206

Start Date: 27/06/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/28

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2435	Rev E1

120		0.00
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**\*120\***

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

UHMW 1"

12-7-8

130

0.00

**\*130\***

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining  
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435  
3-Deburr

PO 12/07/14

12-07-13

140

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*140\***

QC

Memo

0.00

Quality Control

PO 12/07/14

12-07-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86342

**\*86342\***

Page 2

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Revision ID:

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Start Date: 27/06/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC8- Inspect parts - second check

0.00

**\*150\***

QC

Memo

0.00

Quality Control

*OK 12/07/16*

*10*

*10*

151

Identify as per dwg & Stock Location:

0.00

**\*151\***

Packaging

Memo

*111 87886 6x*

0.00

Packaging

*111 87885 4x*

190

QC21- Final Inspection - Work Order Release

0.00

**\*190\***

QC

Memo

0.00

Quality Control

*12/17/17 (10)*

*12/17/20*

*MLJ 12/07/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

June-27-12 3:19:44 PM

Work Order ID: 86342

Parent Item: D2435

Parent Item Name: Bearpaw, 206

\*86342\*

\*D2435\*

Page 1

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 10.00

Required Qty: 10.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MUHMWB10

Purchased

No

120

sf

72.0100

3.2

32

**\*MUHMWB10\***

\*\*

B12-7-5

UHMW 1" Black

### Location

### Loc Qty

### Loc Code

MAT018

48.9

120972

1

121346

27.1

121954

20.8

MAT019

1.5

118814

1.5

ST052

21.60999474

121277

12.8

121278

8.80999474

122286

10

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	86342
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.072	✓		vern	RT-4
B	5.500	+/-0.030	5.504	✓		"	
C	0.200	+/-0.030	<del>2.000</del> 1.91	✓		depth gauge	RT-06
D	R0.250	+/-0.030	.250	✓		rad gauge	
E	0.250	+/-0.010	.248	✓		vern	RT-4
F	0.625	+/-0.030	.630	✓		"	
G	0.25 x 45°	+/-0.030	.252	✓		"	
H	0.375	+/-0.010	.389	✓		"	
I	19.000	+/-0.030	19.000	✓		Tape	RT-10
J	0.950	+0.030/-0.010	.954	✓		vern	RT-4
K	Ø0.260	+0.005/-0.000	.260	✓			
L	Ø0.930	+/-0.030	.931	✓		m/c	RT-001
M	0.30	+0.030/-0.000	.311	✓		depth gauge	RT-06
N	0.375	+/-0.030	.382	✓		vern	RT-4
O	7.375	+/-0.030	7.375	✓		Tape	RT-10
P	4.250	+/-0.010	4.257	✓		vern	RT-4
Q	2.000	+/-0.030	2.004	✓		"	
R	9.000	+/-0.010	9.000	✓		Tape	RT-10
S	15.750	+/-0.030	15.750	✓		"	

Measured by: <i>RT</i>	Audited by: <i>OK</i>	Prototype Approval:	N/A
Date: 12-03-13	Date: 12/07/16	Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF <i>RF</i>	<i>RT</i>

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**NOTE:** Date & initial all entries





RELEASED  
96.06.17 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD
KE	KE	HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
98.05.19		D2435
DATE	TITLE	SHEET 1 OF 2
	BEARPAW	SCALE
		1:5

ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 86342 MLW

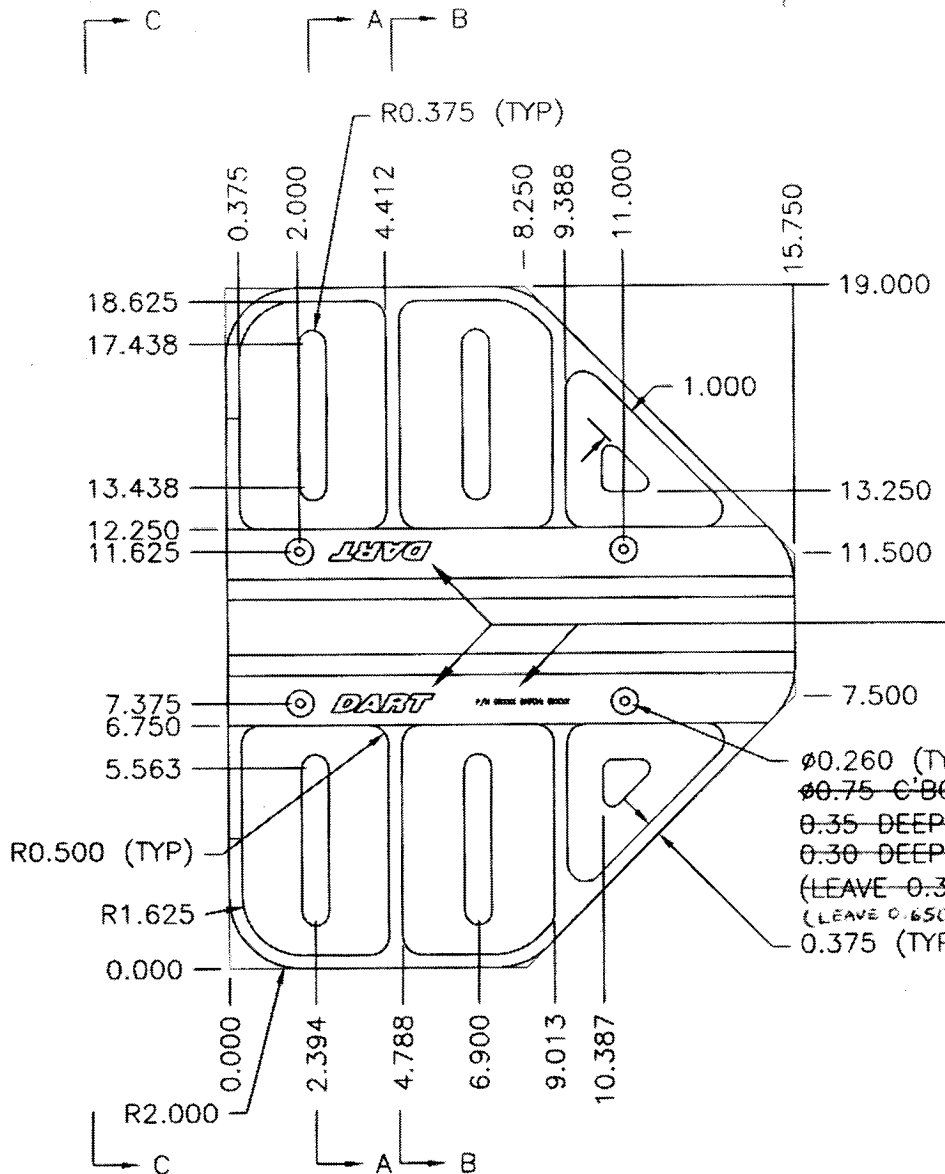
12/06/28

$\phi 0.260$  (TYP)  $\phi 0.93$  C'BORE  
 ~~$\phi 0.75$  C'BORE~~ 0.30 DEEP FROM BOTTOM  
0.35 DEEP FROM TOP (MIN.)  
0.30 DEEP FROM BOTTOM  
(LEAVE 0.300 MIN.)  
(LEAVE 0.650 MIN.)  
0.375 (TYP)



9143	
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EFFECTIVE DEOS



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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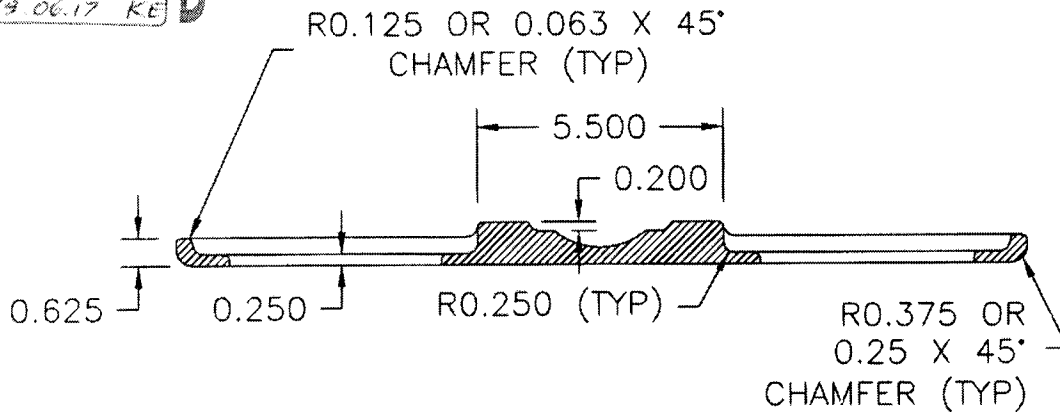
NOTE: Date & initial all entries

26342

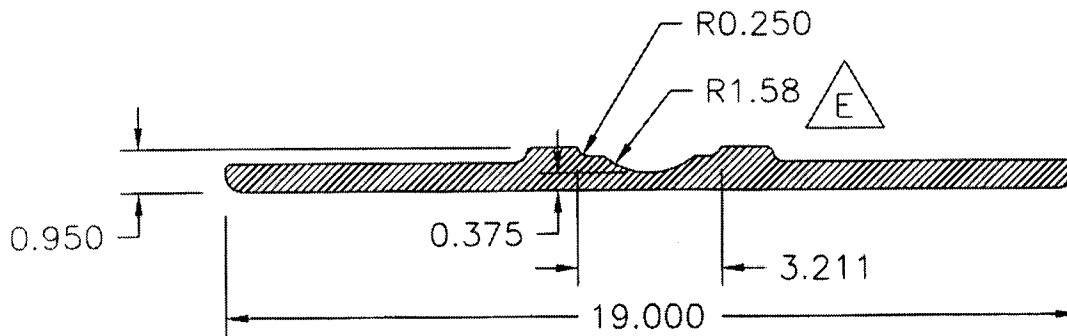


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED MB	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

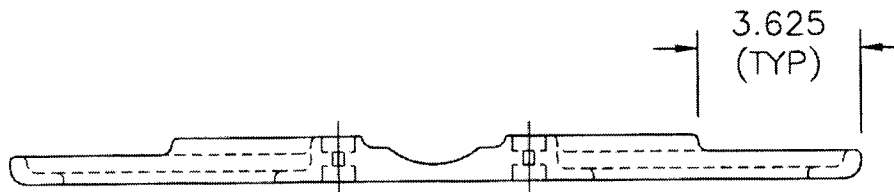
RELEASED  
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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